



Dart Aerospace Ltd.
1270 Aberdeen St
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Canada

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D3916-041
Job Sheet 205691



Part No: D3916-041

Job Qty: 6 pcs

Part Name: Rib Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/16/20

Job Tracking No:

Due Date: 2/10/20

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV A IPP RevA: New issue DD verified by:EC IPP Rev:B as per dwg revA 10.03.15 verified by:EC
Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup	Run	Workcenter / Supplier	Lead Time	
100	Large Fab - Basket - 1	6 pcs	2/10/20		0.00	2.73	Large Fab - 1		
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
							Large Fab - 11 (Various)		
							Large Fab - 12		
105	QC 5	6 pcs	2/10/20		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							QC 5 - 61		
							QC 5 - 81		



Container No: S258843



Part: D3916-041

Job No: 205691

Serial No/Batch: S258843

Revision:

Inspector:

Exp Date:

Instructions: Various ETC's

Dart Aerospace Ltd.
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CANADA
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www.dartaerospace.com

Date: 02/27/20

DAS
24
9-89

Plex 1/16/20 10:58 AM Dart.lajeunesse.marie

107	Large Fab - Basket - 2 - B4B	6 pcs	2/10/20	0.00 3.43	Large Fab - 1 - B4B Large Fab - 10 - B4B Large Fab - 2 - B4B Large Fab - 3 - B4B Large Fab - 4 - B4B Large Fab - 5 - B4B Large Fab - 6 - B4B Large Fab - 7 - B4B Large Fab - 8 - B4B Large Fab - 9 - B4B Large Fab - 11 - B4B (Various) Large Fab - 12 - B4B	KS/CC
110	QC 5	6 pcs	2/10/20	0.00 0.00	QC 5 - 10 QC 5 - 12 QC 5 - 17 QC 5 - 18 QC 5 - 19 QC 5 - 22 QC 5 - 24 QC 5 - 3 QC 5 - 43 QC 5 - 49 QC 5 - 51 QC 5 - 58 QC 5 - 68 QC 5 - 9 QC 5 - 50 QC 5 - 30 QC 5 - 40 QC 5 - 61 QC 5 - 81 QC 10 - 10 QC 10 - 18 QC 10 - 24 QC 10 - 43 QC 10 - 50 QC 10 - 58 QC 10 - 9 QC 10 - 68	DAS 43 9-89
120	QC 10	6 pcs	2/10/20	0.00 0.00	QC 10 - 10 QC 10 - 18 QC 10 - 24 QC 10 - 43 QC 10 - 50 QC 10 - 58 QC 10 - 9 QC 10 - 68	DAS 43 9-89
130	Packaging 3-1 - Stock - B4B	6 pcs	2/10/20	0.00 0.00	Packaging 3 - 1 - B4B Packaging 3 - 2 - B4B Packaging 3 - 3 - B4B Packaging 3 - 4 - B4B Packaging 3 - 5 - B4B Packaging 3 - 6 - B4B Packaging 3 - 7 - B4B Packaging 3 - 8 - B4B Packaging 3 - 9 - B4B Packaging 3 - 10 - B4B Packaging 3 - 11 - B4B Packaging 3 - 12 - B4B Packaging 3 - 13 - B4B Packaging 3 - 14 - B4B Packaging 3 - 15 - B4B Packaging 3 - 16 - B4B Packaging 3 - 17 - B4B Packaging 3 - 18 - B4B Packaging 3 - 19 - B4B	DAS 43 9-89

				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	
140 QC 21 - SA	6	2/10/20	0.00 0.00	QC 21 - SA - 21	
	pcs			QC 21 - SA - 70	
				QC 21 - SA - 53	

MAR 02 2020

Part Op 100 - 1- Cut tube 50" 2- Bend tube with manuel pipe bender as per DT9567 *** Make line at 9.00" and use jig for other Descriptions: lines, and ensure seam in place on side of tube when bending*** 3- Trim access tube material to finish size as per dwg D3916 4- Drill and chamfer holes as per dwg D3916-1 using DT9605

105 - (QC5- Inspect part completeness to step on W/O)

107 - (Weld per dwg A/R S.S. rod Batch: M39023) 1- weld bushing as per dwg D3916 2- grind welds flush

110 - (QC5- Inspect part completeness to step on W/O)

120 - (QC10- Inspect visual per QSI004- ground welds)

130 - (Identify as per dwg & Stock Location: _____) LOCATION: WA004-5

140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3759-1	Bushing	42 pcs (7 ea)	100-Large Fab - Basket - 1	5254412
M304TS0.750W.049	304 Sq Tube .75X.75X.049W	24.9960 ft (4.166 ea)	100-Large Fab - Basket - 1	5251118

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Basket - 1	D3759-1	42	126	0
	M304TS0.750W.049	25	158	0

Part Specifications

Specifications could not be found.

Plex 1/16/20 10:58 AM Dart.lajeunesse.marie

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐



Job: _____ Part No. _____		DISPOSITION		DEPARTMENT/PROCESS		MRB (QS1042)																	
Date: _____		Sequence #: _____		QTY Affected: _____		MRB (QS1042)																	
Description Work Order Deviation		Disposition																					
Root Cause <table border="1"><tr><td>Operator</td><td></td></tr><tr><td>Manufacturing Process</td><td></td></tr><tr><td>Equip/Tooling</td><td></td></tr><tr><td>Handling/Preservation</td><td></td></tr><tr><td>Material</td><td></td></tr><tr><td>Product Improvement</td><td></td></tr><tr><td>Process Improvement</td><td></td></tr><tr><td>Human Factors</td><td></td></tr></table>		Operator		Manufacturing Process		Equip/Tooling		Handling/Preservation		Material		Product Improvement		Process Improvement		Human Factors		FAULT CATEGORY					
		Operator																					
Manufacturing Process																							
Equip/Tooling																							
Handling/Preservation																							
Material																							
Product Improvement																							
Process Improvement																							
Human Factors																							
		Pressure/Forced Bending Crushing Cracks Crimp/Kink/Ripple/Wave/Twist Marks/Chatter Mislabeled Other/Details: _____		Contamination Misaligned/off center BOM/Route Broken/Damage/Defect Incomplete/Unclear Instructions Drill Holes Fit/Function		Power Loss/Surge Folio/Program Grain Direction Weld Wrong Stock Pulled Out of Sequence Off-set/Set-up		Positioned Wrong Outside Tolerance Drawing Finish Part Lost/Missing Misread															
								Completed By		Lead hand / Supervisor		QC / QA Coordinator											